



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1009-9
Job Sheet 173632



Part No: RBST1009-9

Job Qty: 10 ea

Part Name: Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST1009 THRU 1020 Rev 7 IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/13/18	0.00	0.00	Start Up Machining-3		J.C.-L.
110	Lathe Conv	10 pcs		3/13/18	0.00	5.00	Lathe Conv-1		J.C.-L.
120	QC	10 pcs		3/13/18	0.00	0.00	QC2 Machining-4		J.C.-L.
130	Mill Conv	10 pcs		3/14/18	0.00	2.50	Mill Conv 1		J.C.-L.
140	QC	10 pcs		3/14/18	0.00	0.00	QC2 Machining-4		J.C.-L. 18-04-06
150	QC	10 pcs		3/14/18	0.00	0.00	QC8 Machining-4		
180	Outsource	10 pcs		3/14/18	0.00	0.00	Outsource12		
190	Packaging	10 pcs		3/14/18	0.00	0.00	Packaging2		
200	QC	10 pcs		3/14/18	0.00	0.00	QC6		
210	Packaging	10 pcs		3/14/18	0.00	0.00	Packaging3-1		
220	QC21-SA	10 Ea		3/14/18	0.00	0.00	QC21		M.G.

Part Op 110 - 1-Machine as per DWG. 2-Deburr
Descriptions: 180 - Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98378A909	Perforator Pin .129" X 2-1/2"	10 Ea (1 ea)	90-Start up Operation	5050191 x 10

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	98378A909	10	5	0



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Part Specifications

Specifications could not be found.

Container No: S057143



Part: RBST1009-9

Job No: 173632

Serial No/Batch: S057143

Revision: 7

Inspector:

Plex 3/6/18 9:04 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>173 632</u> Part No. <u>RJST 1009-9</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Date: <u>18-04-02</u>		Step #: <u>110</u>		QTY Effective: <u>10</u>		MRB (QS1042) Approval DAS 9 9-89 <u>18-04-09</u>																																																																									
Description Work Order Deviation				Disposition																																																																											
Printed a unclear drawing, the Ø 0.188 is at 0.166. unclear drawing Drawing was printed by employee but printer used printed out an unclear page. (too small of a dimension)				Scrap destroy no replace.		Completed By																																																																									
						J.C.-L. 18-04-02																																																																									
						Lead hand / Supervisor Approval Verification <u>and</u> 18/04/03																																																																									
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Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>☒ No Re-verification</td> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>☒ Operator</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>☒ Outside Dimensions</td> </tr> <tr> <td>Doc/Data ☐</td> <td>☐ Offset/Setup</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>☐ Supplier</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>☐ Training</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>Material ☐</td> <td>☐ Use for Testing</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>☐ Part Moved</td> </tr> <tr> <td>Internal Transport ☐</td> <td>☐ Poor Information</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>☐ Drawing</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>☐ Rushing</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>☐ Finish</td> </tr> <tr> <td>LOA ☐</td> <td>☐ Product Improvement</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>☐ Misread</td> </tr> <tr> <td>Substation ☐</td> <td>☐ Process Improvement</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>☐ Turning Sequence</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>☐ Manufacturing Process</td> <td colspan="4"></td> </tr> <tr> <td>Misidentified ☐</td> <td>☐ Past Due</td> <td colspan="4"></td> </tr> </table>				Environment ☐	☒ No Re-verification	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	☒ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	☒ Outside Dimensions	Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	☐ Over/Under tolerance	Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	☐ Part Incorrect	Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	☐ Part Lost/Missing	Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	☐ Part Moved	Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	☐ Drawing	Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	☐ Finish	LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	☐ Misread	Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	☐ Turning Sequence	Past Expiry Date ☐	☐ Manufacturing Process					Misidentified ☐	☐ Past Due					FAULT CATEGORY OTHER : _____			
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173632

Page 1 of 1

Caliper

2.6.4

Engineering Approval:
(If necessary)

Rev

4/2/2018

[Dart Hawkesbury] Scrap Summary by Part - Gagnon-Donovan, Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Scrap Summary by Part

4/1/18 To 4/30/18

Part No: rbst1009-9

Quantity Type: Shipped

Operations: All Ops

PPM Reasons Only: No

Date: 4/1/18 To 4/30/18

Sort by: Part_No

Supplier Scrap: Include

Workcenter: All

Part Type: All

Produced Op Type: All

Scrap Tracking Number: All

Part No	Name	Shipped Quantity	Scrap	Total Scrap Quantity	Price Value (\$)	Scrap %
			Dimensional			
RBST1009-9	Pin	0	10.000	10.000	.00	100.00
1 Parts		0	10.000	10.000	.00	100.00

rbst1009-9 PPM Info

Total Shipped	0
Shipped PPM	0
Total Produced	0
Produced PPM	0

Plex 4/2/18 3:37 PM Dart.Gagnon.Michelle Page 1



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Container History for S057143

Change Date	By	Job	Part	Rev	Operation	Material	Chg	Serial No/Batch	Gross	Tare	Net	Len	Qty	Location	Status	Accounting Job	Defect	Type
4/2/18 6:08 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Start up Operation			S057143	0	0	0	0	0	Start Up Machining-3	WIP			Created at C
4/2/18 6:09 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Start up Operation			S057143	0	0	0	0	10	Start Up Machining-3	WIP			Production
4/2/18 7:58 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Start up Operation			S057143	0	0	0	0	10	Lathe Conv-1	Allocated			Loaded to 1
4/2/18 7:59 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Lathe Conv			S057143	0	0	0	0	10	Lathe Conv-1	Allocated			Record Op
4/2/18 7:59 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Lathe Conv			S057143	0	0	0	0	10	Lathe Conv-1	Allocated			Production
4/2/18 7:59 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Lathe Conv			S057143	0	0	0	0	10	Lathe Conv-1	WIP			Bin Container F
4/2/18 8:01 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Lathe Conv			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Loaded to 1
4/2/18 8:01 AM	Charest-Lacombe, Julien	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Record Op
4/2/18 8:01 AM	Charest-Lacombe, Julien	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Production
4/2/18 8:01 AM	Charest-Lacombe, Julien	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Container F
4/2/18 10:44 AM	Charest-Lacombe, Julien	173632	RBST1009-9		QC			S057143	0	0	0	0	10	Mill Conv 1	WIP			Bin Loaded to 1
4/2/18 10:44 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Mill Conv			S057143	0	0	0	0	10	Mill Conv 1	WIP			Bin Record Op
4/2/18 10:44 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Mill Conv			S057143	0	0	0	0	10	Mill Conv 1	WIP			Bin Production
4/2/18 10:45 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Mill Conv			S057143	0	0	0	0	10	Mill Conv 1	WIP			Bin Container F
4/2/18 10:45 AM	Charest-Lacombe, Julien	173632	RBST1009-9		Mill Conv			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Loaded to 1
4/2/18 10:45 AM	Charest-Lacombe, Julien	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Record Op
4/2/18 10:45 AM	Charest-Lacombe, Julien	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Production
4/2/18 10:45 AM	Charest-Lacombe, Julien	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC2 Machining-4	WIP			Bin Container F
4/2/18 3:27 PM	Gagnon-Donovan, Michelle	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC8 Machining-4	WIP			Bin Loaded to 1
4/2/18 3:28 PM	Gagnon-Donovan, Michelle	173632	RBST1009-9		QC			S057143	0	0	0	0	10	QC8 Machining-4	Scrap			Bin Scrap Cont

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			